

Work Order ID 110438

December-19-13 2:44:31 PM

110438

Page 1

Item ID: D206-642-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 12/19/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/02/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-19 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2650	Rev F(DEO)
-------	------------

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-241

CHG006

N/A MLJ 14-01-30

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Item ID: D206-642-241 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 12/19/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/02/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch
 A/R Aluminum Rod M27069

4-Grind weld flush to cap on top surface only.

✓ Cut Aft end as per dwg 2650 from front of tube and Deburr

✓ Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

✓ Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

- DC 13/12/30

13-12-31 PD

mm 13/12/31

14-01-07 DGL

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Cust Item ID:

Required Date: 1/02/14 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

16-Open crossbolt holes to Ø0.3125"

17-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

18- Ream crossbolt spacer holes to finished size as per Dwg D2650, D2650-3 Drilling Detail ***DO NOT OPEN X-BOLT SPACER HOLE OF DETAIL B***

19-Deburr tube as per QSI 018 and blow out chips from inside the tube

14-01-07 DGL

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				1			
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	0	14-01-07	DAS 18 9-89
140 *140* Hand Finish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	0	14-01-07 DGL	

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Stop ***NS2***

Start Date: 12/19/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/02/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

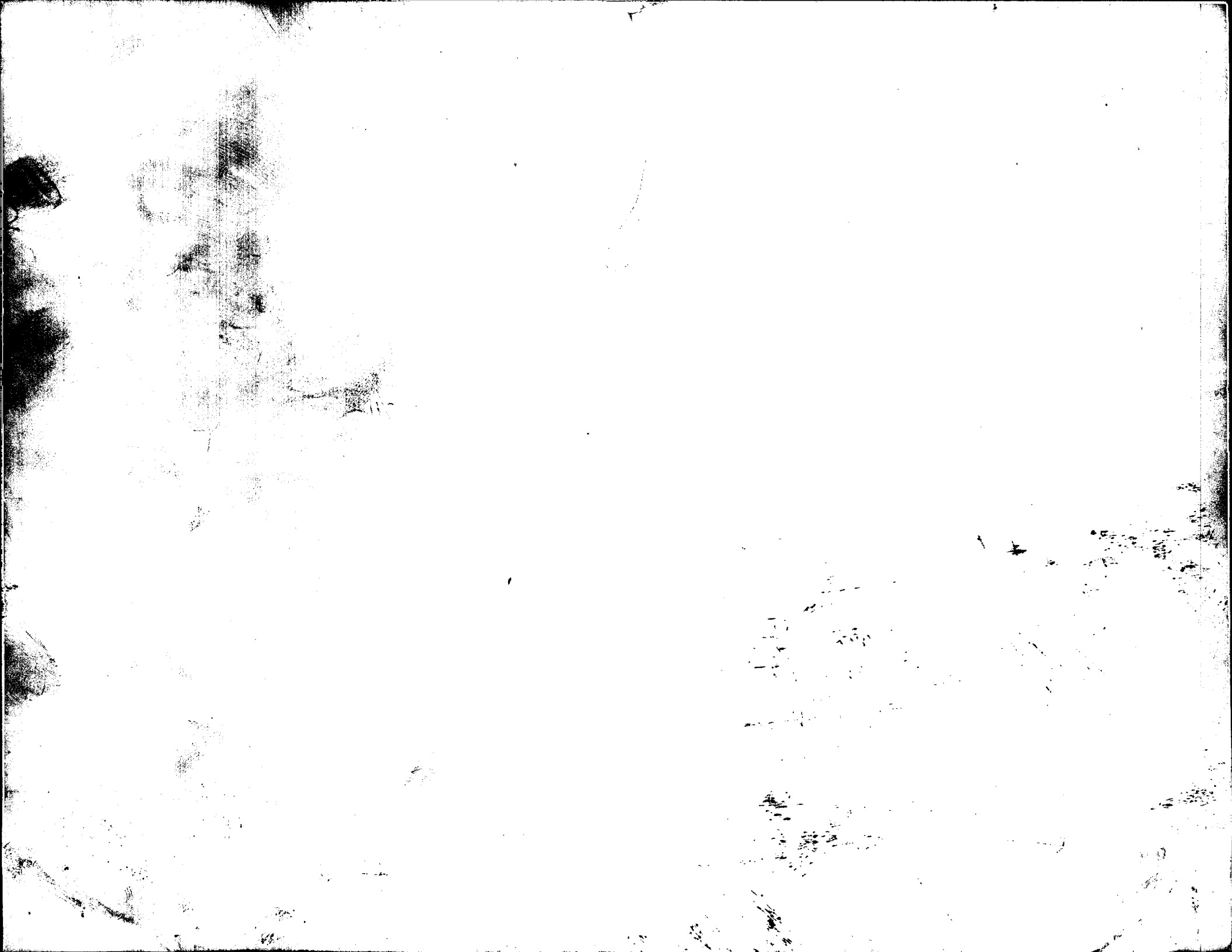
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00				1	0	DC 14/01/08	
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Skidtubes							DC 14/01/08	
Skidtubes	Memo	0.00							
Skidtubes	1- Open and c/sink one crossbolt spacer holes as per Dwg D2650 (DEO Detail B)(without cutting fluid)								
	2-Deburr and blow out all chips from inside the tube								

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Required Date: 1/02/14 Req'd Qty: 1.00 ***1***

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Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

1-Remove alodine in one area per DEO detail B from around hole and prepare for welding

2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch
A/RAluminum Rod M122324

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

5- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

6- Install D2680-041 Nut Plate as per Dwg D2650

BB 14/01/10

DC 14/01/09

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 Required Date: 1/02/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
220									DAS
QC	Memo	0.00				①	14-01-12		9 9-89
Quality Control									
230	QC5- Inspect part completeness to step on W/O	0.00							
230									DAS
QC	Memo	0.00				J			27 9-89
Quality Control									14/1/10
240	Pressure Wash per QSI005 4.3	0.00							
240									
HandFinish	Memo	0.00				1	HG	13/1-14	
Hand Finishing	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								

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Cust Item ID:

Required Date: 1/02/14 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

270

HandFinish

HandFinishing

0.00

0.00

Memo

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RSikaflex-291 11/17/09

Sikaflex expire date: 1/4/10

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/RSikaflex-291 1/14/09

Sikaflex expire date: 1/14/10

5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4

A/R Batch: 1/14/09

300

300

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

DAS
27

9-89

4/1/08

1x 1 11/14/09

1

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 Required Date: 1/02/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310	Packaging	0.00							
310									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-241								
	Location: _____								
	PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

1 8 14-01-29

MLG 14-01-30

(A) 14-01-30

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Work Order ID: 110438

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Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: 04.12.02 Revised procedural stepsKJ/JLM IPP RevP: revise
and update route/bom DD 10.01.06 verf:ECIPP rev Q 10.02.19 per PAR
09-043 EC verified by: DD IPP Rev:R 12.11.22 now swage per ecn12-
679 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured

No

110

Each

12.0000

1

1

D2620

Skidtube, 206 Skidtube

**

DC 13/12/30

Location

Loc Qty

Loc Code

LG002

12

108384

12

D4720-1

Manufactured

No

200

Each

428.0000

17

17

D4720-1

Spacer

**

DC 14/01/09

Location

Loc Qty

Loc Code

LG001

428

103902

428

D3286-1

Manufactured

No

110

Each

97.0000

2

2

D3286-1

Doubler

**

Location

Loc Qty

Loc Code

LG001

97

90503

9

91158

88

2

D644-1-7

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Work Order ID: 110438

110438

Parent Item: D206-642-241

D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

D2647 Manufactured No 110 Each 22.0000 1 1

D2647

Cap

PD 13-12-31

Location

Loc Qty

Loc Code

LG001

22

102371

7

107588

15

D2654-3

Manufactured No

180 Each

7.0000

1

1

D2654-3

Web

DE 14/01/08

Location

Loc Qty

Loc Code

LG002

7

105172

3

109991

4

CR3212-4-04

Purchased No

180 Each

932.0000

52

52

CR3212-4-04

Cherry Rivet

DE 14/01/08

Location

Loc Qty

Loc Code

ST327

123

123265

123

st552

809

m126534

62

m126691

747

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110438

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D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 200 Each 419.0000 1 1

D2649

Cross Bolt Spacer

BE 14/01/09

Location Loc Qty Loc Code

LG001 419

107906 208

108633 176

90497 6

93662 28

D3286-3 Manufactured No 200 Each 137.0000 2 2

D3286-3

Spacer

BE 14/01/09

Location Loc Qty Loc Code

LG001 137

109097 61

91160 76

D2680-041 Manufactured No Each 16.0000 1 1

D2680-041

Nut Plate

DC 14/01/09

Location Loc Qty Loc Code

ST014 16

108819 16

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Work Order ID: 110438

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D206-642-241

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Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

Each

825.0000

2

CR3212-4-03

**

Cherry Rivet

DC 14/01/09

Location

Loc Qty

Loc Code

ST327

725

114889

7

119017

700

123263

18

st552

100

m114859

100

②

CCR264SS3-3

Purchased

No

Each

422.0000

2

CCR264SS3-3

**

Cherry Rivet

DC 14/01/09

Location B126474

Loc Qty

Loc Code

ST327

422

m126282

222

m126333

200

②

D2646

Manufactured

No

270

Each

46.0000

1

1

D2646

**

Aft Cap

14/01/23

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

42

103306

18

107857

24

VI

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D206-642-241

Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No 270 Each 428.0000 18 18

D2651-1

Plug

HL 11/01/23

Location

Loc Qty

Loc Code

FP001

428

103305

30

103858

64

104843

199

106456

135

X18

NAS1149D0463J

Purchased

No

270

Each

484.0000

1

1

NAS1149D0463.J

WASHER

HL 11/01/23

Location

Loc Qty

Loc Code

ST510a

484

M127693

484

X1

D2651-3

Manufactured

No

270

Each

550.0000

18

18

D2651-3

O-Ring

HL 11/01/23

Location

Loc Qty

Loc Code

FP001

550

102315

60

104725

330

108583

160

X18

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D206-642-241

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Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

270

Each

980.0000

46

46

MS27039-1-08

Screw

Location

Loc Qty

Loc Code

GA

63

m125654

63

st507

917

m126319

417

m127255

500

X46

ALS4-1032-130

Purchased

No

270

Each

2,255.000

44

44

ALS4-1032-130 ALS4-1032-130

Rivnut

Location

Loc Qty

Loc Code

st510

1917

M126109

1917

st555

338

M127028

338

X44

MS27039-4-06

Purchased

No

270

Each

100.0000

1

1

MS27039-4-06

Screw

Location

Loc Qty

Loc Code

ST306

100

m126534

100

X1

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Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

270

Each

2,309.000

46

46

NAS1149D0332.J

Washer

ll 12/10/13

Location

Loc Qty

Loc Code

ST293

837

m127431

837

ST294

72

m125807

72

ST510a

1400

m127374

400

m127389

1000

✓ 1/6

D3537-1

Manufactured

No

270

Each

20.0000

4

4

D3537-1

Wearpad

ll 12/10/13

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

2

108118

2

B110341

✓ 4

D3537-3

Manufactured

No

270

Each

22.0000

1

1

D3537-3

Wearpad

ll 11/01/13

Location

Loc Qty

Loc Code

FG

8

86237

8

FP002

14

103014

14

B104350

✓ 1

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Parent Item Name: Replacement Skidtube, High Gear(Fits LH or RH)

Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

D3535-13

Manufactured No

270

Each

4.0000

1

1

D3535-13

Stainless Steel Wearplate Fwd

**

14/01/23

Location

Loc Qty

Loc Code

FG

2

B110348

X1

86229

2

FP001

2

102261

2

D3536-13

Manufactured No

270

Each

10.0000

1

1

D3536-13

Gasket Fwd

**

14/01/23

Location

Loc Qty

Loc Code

FG

6

B110777

X1

81344

2

89686

4

FP001

4

108532

4

D3535-21

Manufactured No

270

Each

12.0000

1

1

D3535-21

Stainless Steel Wearplate Center Fwd

**

14/01/23

Location

Loc Qty

Loc Code

FP001

12

102342

12

D3536-21

Manufactured No

270

Each

14.0000

1

1

D3536-21

Gasket Center

**

14/01/23

Location

Loc Qty

Loc Code

FP001

14

104203

14

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Start Date: 12/19/13

Required Date: 1/02/14

Start Qty: 1.00

Required Qty: 1.00

D3535-33

Manufactured No

270

Each

3.0000

1

1

D3535-33

Stainless Steel Wearplate Aft

12/10/13

Location

Loc Qty

Loc Code

FP002

3

B110205

X1

98973

3

D3536-33

Manufactured No

270

Each

7.0000

1

1

D3536-33

Gasket Aft

12/10/13

Location

Loc Qty

Loc Code

FP001

7

B110836

X1

101835

7

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

110438 MLJ
13-12-19

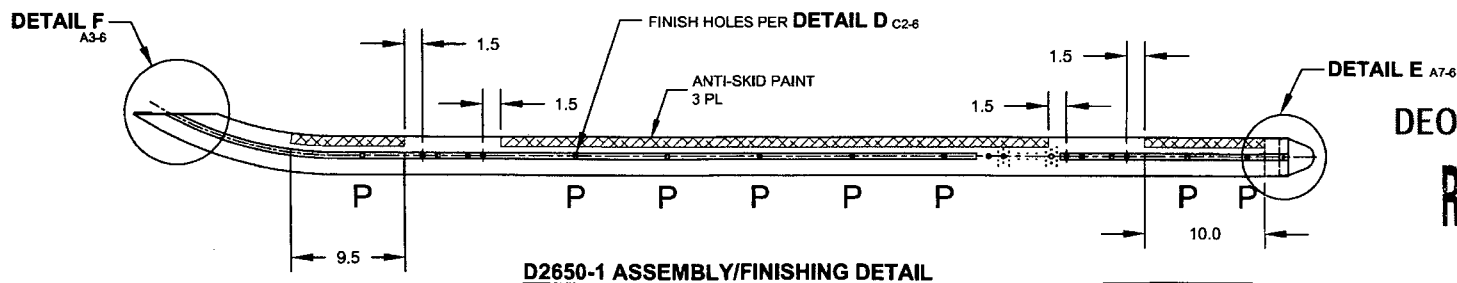
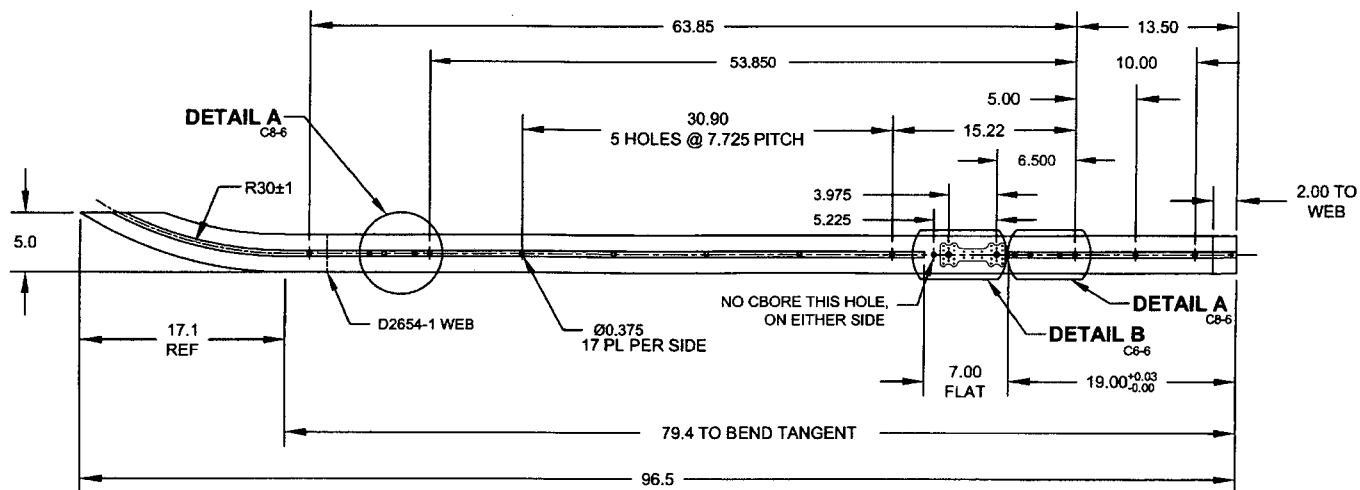
DEO ATTACHED

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08-07-23




NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED




F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE. CHG DRILL. ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

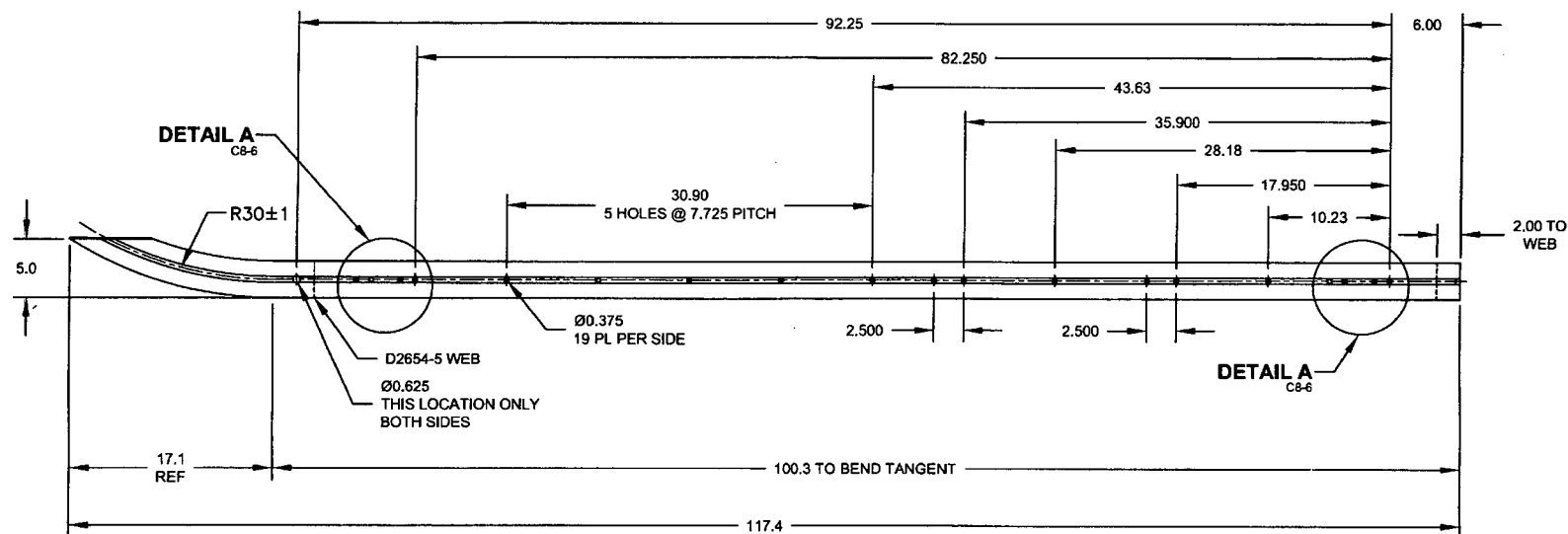


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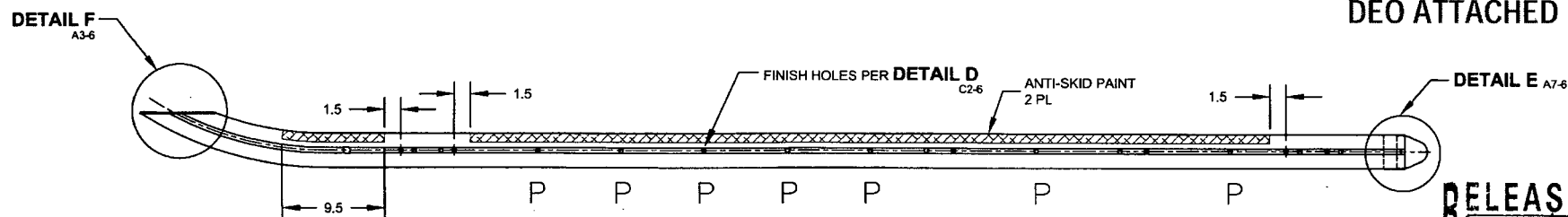
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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D2650-5 BENDING/DRILLING DETAIL

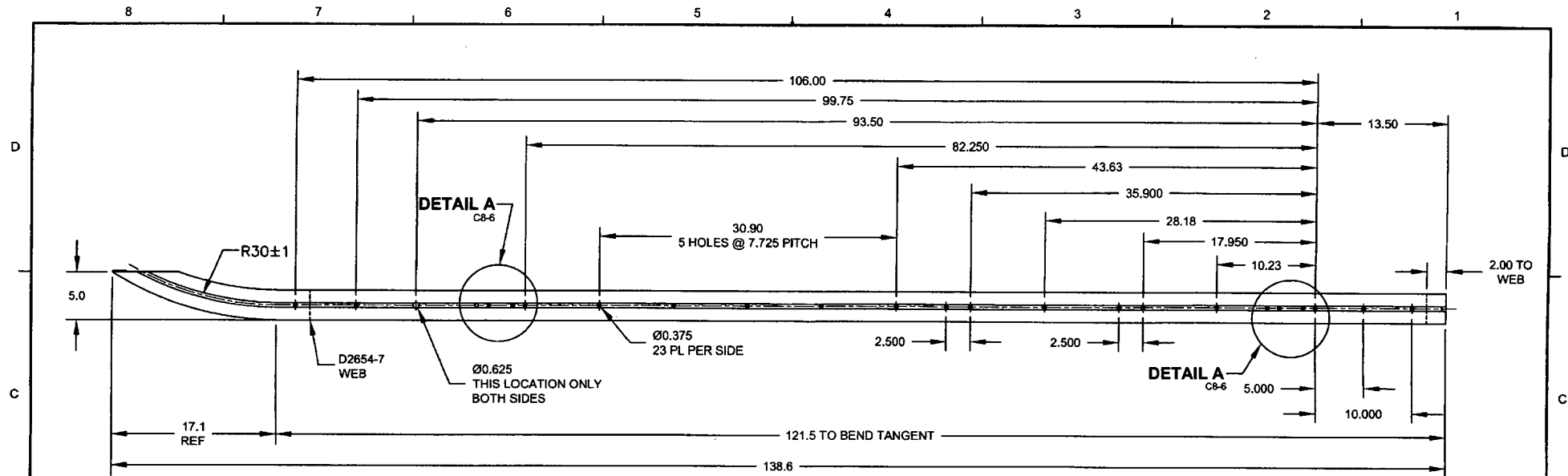


D2650-5 ASSEMBLY/FINISHING DETAIL

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OCT 29 22 1977

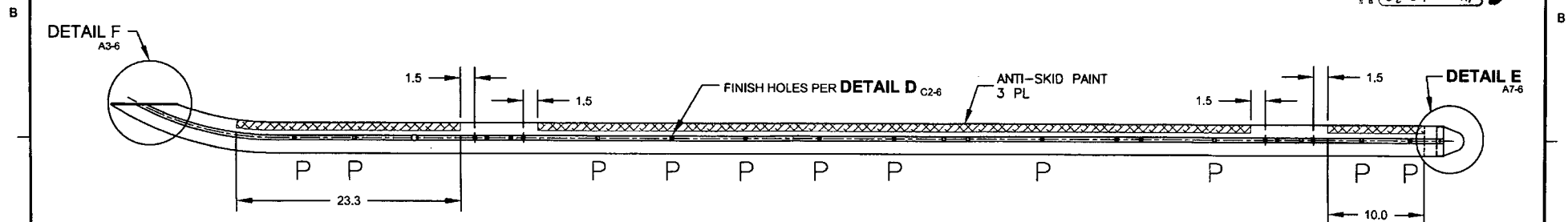
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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D2650-7 BENDING/DRILL DETAIL

DEO ATTACHED

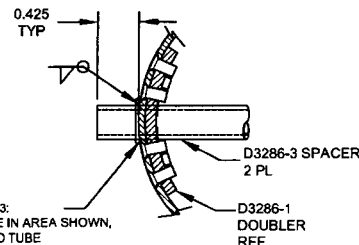
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02 07-22



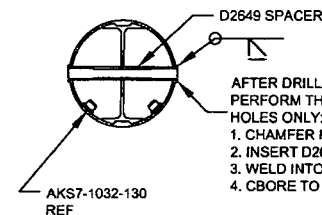
D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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SECTION C-C C7-6
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP

DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5

DETAIL F NOTES:

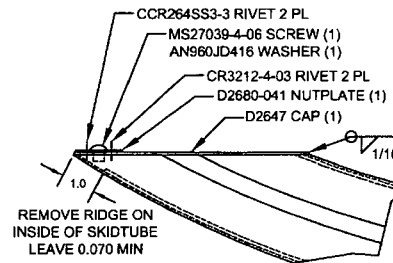
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-08-08
DEO ATTACHED

DETAIL F
SCALE NONE

B8-2
B8-3
B8-4
B8-5



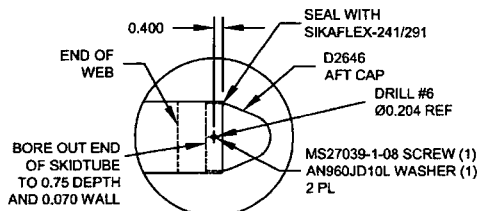
REMOVE RIDGE ON INSIDE OF SKIDTUBE
LEAVE 0.070 MIN

ORIENTATION OF
D2680-041



DETAIL E
SCALE 2X

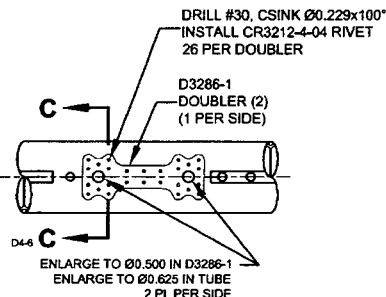
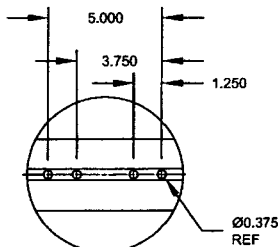
B2-2
B2-3
B1-4
B1-5



BORE OUT END OF SKIDTUBE TO 0.75 DEPTH AND 0.070 WALL



DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5



DETAIL B
SCALE 2X

C3-2
C3-3

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED A.P.	MFG. APPR. <i>DA</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

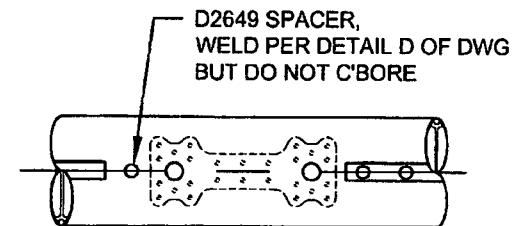
QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.

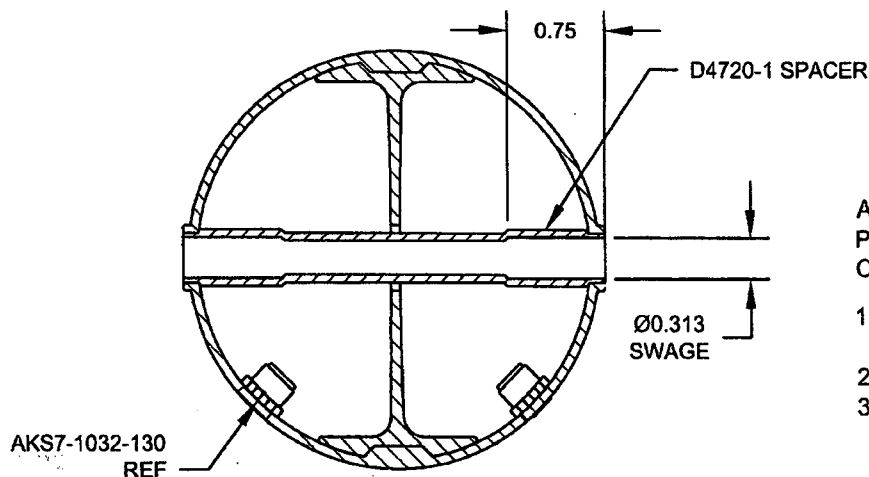
C'BORED HOLES ARE **NOW SWAGED** PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

FOR Ø0.375 HOLES ONLY

FOR HOLES THAT ARE CURRENTLY C'BORED ONLY

NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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